

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027822**Date Inspected:** 23-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

ESW Testing and Documentation

At approximately 11:30am on the date of 06-22-12 this QA had a meeting in the Tower ESW work area at the 9m elevation. Those in attendance were Mazen Wabeh, Bill Casey, Brian Maroney, Mohammad Awal, Jim Bowers, Aaron Prchlik, Robert Mertz, and Leonard Cross. In this meeting was discussed the status of ESW excavations and repairs to date. This QA performed information only Ultrasonic Testing (UT) of ESW G for those in attendance to provide examples of possible transverse indications discovered during QC and QA Ultrasonic Testing. This QA also provided photographic examples of indications discovered during ESW excavation for repair of UT rejectable indications. These indications were discovered both visually and through the Magnetic Particle Testing (MT) process.

Mr. Wabeh instructed this QA to compile a series of chronological photographs to illustrate the step by step process used in the discovery, excavation, testing, documentation, removal, and repair of these discovered indications.

This QA spent approximately 6 hours of this days shift sorting and editing for text, these requested photographs. This QA was instructed that these photographs were needed by Monday, June 25th.

The requested photographs were emailed to Mr. Wabeh, Mr. Prchlik, Mr. Mertz, and to this QA's task leader Bill Levell.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Ultrasonic Testing of ESW

This QA performed Ultrasonic Testing (UT) on approximately 1730mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW H". Location (Y=7870~9600) of this weld was inspected using this testing method.

This weld was previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3.

This QA observed one (1) recordable indication approximately 1600mm in length at the time of testing. This indication was not recorded by QC technicians at the time QA performed this testing. This QA generated a TL-6027 UT report on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations as listed above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
